

Work Order ID 56132

February 10, 2010 2:52:15 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *M*Date: *10-2-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

*> DD**10-2-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Skidtubes

Skidtubes

Memo

0.00

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

fy do mb 10-02-22

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

x1 BE 10/02/22

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Skidtubes

Skidtubes

0.00

0.00

Memo

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R ☐ ☐ Aluminum Rod M113207

86 10/02/23

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R ☐ ☐ Aluminum Rod M113207

86 10/02/23

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

10-2-23

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Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00

8.10/02/24



QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

8.10/02/24



QC

Memo

0.00

Quality Control

AC

170

Pressure Wash per QSI005 4.3

0.00

=> M 10/03/09



HandFinish

+Recalodine as per PAR09-043

Memo

0.00

Hand Finishing

XT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



Stop

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Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M113170

0.00

=> 10/03/09

(X1) 0

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BL 10-3-10

0.4

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Customer:

Reference:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 112345

Sikaflex expire date: 10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ 112345

Sikaflex expire date: 10/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 113462

7
BL 10-3-10. ①

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 10/5/11

40

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev: PPP 56756

Rev 3/11 C

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/63/16 J

MF 0-3-11

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2580-1		Manufactured	No			110	Each	5.0000	1.0000			

205 Skidtube bent detail

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

54541

54697

54721

B 56123

5

2

2

1

1

M12/2/18

D2576-3



Step (maching detail)

Manufactured

No

140

Each

141.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46661

52215

141

94

47

BE 10/02/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Replacement Skidtube



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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2579	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 140	Unit of Each	Qty on 147.0000	Remaining 20.0000	Qty	Date	Status
												
Crossbolt Spacer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
LG	25	
51525	4	
53780	3	
54543	18	
Main Warehouse		
ST	122	
43988	4	
46434	4	
46956	2	
47797	9	
48272	2	
51314	71	
51315	30	

256145

*20

BE 10/02/23

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2855	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 200	Unit of Each	Qty on 151.0000	Remaining 1.0000	Qty	Date	Status
-----------------------------	-------------	----------------------	-----------	---------	------	--------------	-----------------	--------------------	---------------------	-----	------	--------



Cap



Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST026	151	
50513	1	
50770	1	
51539	39	
53791 ✓	110	

AN3-5A

Purchased

No

200

Each

1,773.000

2.0000



Bolt



Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1773	
100188	188	
105057 ✓	1585	

1 b/10-3-10

2 b/10-3-10

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ AN960JD10L	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 200	Unit of Each	Qty on 3,459.000	Remaining 2.0000	Qty	Date	Status
----------------------------------	-------------	-------------------	-----------	---------	------	--------------	-----------------	---------------------	---------------------	-----	------	--------



Washer



Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	3459	
101291	16	
105793	49	
110985 ✓	3394	

ALS7-1032-130

Purchased

No

200 Each

986.0000 50.0000



Insert



Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	986	
108606	52	
111529	130	
111779	34	
112772	11	
113238	759	

ALS4-1032-130.

2. BR 10-3-10

50. BR 10-3-10,

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 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN3C4A		Purchased	No			200	Each	1,263.000	50.0000			
BOLT												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST 114103	1263	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	64	
113226	344	
113422	124	
113644	500	
113749	200	

50. 10-3-10

AN960C10L



washer

Purchased

No

200

Each

388.0000 50.0000



Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG 113737	100	
103585	100	
Main Warehouse		
ST	288	
112116	128	
112612	160	

43. 10-3-10

113691

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7. 10-3-10

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3566-13		Manufactured	No			200	Each	83.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 81

53461 ✓ 81

Main Warehouse

ST 2

45717 1

50265 1

D3566-5

Manufactured No

200 Each

34.0000 1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19 30

55026 ✓ 18

55335 12

Main Warehouse

ST 4

36113 1

46186 1

47318 1

51260 1

1/2/10-3-10

1/2/10-3-10

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3566-1		Manufactured	No			200	Each	39.0000	2.0000			
Gasket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP 56532	34	
52512	3	
54480	1	
55011	3	
55320 ✓	27	
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

1 BL 10-3-10.

1 BL 10-3-10.

D3564-11



Wearshoe

Manufactured No

200 Each 5.0000 1.0000



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP19 55332	3	
52125	3	
Main Warehouse		
ST	2	
45823	1	
50112	1	

1 BL 10-3-10.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3564-13		Manufactured	No			200	Each	23.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17

11

51611

11

Main Warehouse

ST

12

45409

2

46495

10

D3564-9

Manufactured No

200

Each

14.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19

12

55025

12

Main Warehouse

ST

2

44659

1

45825

1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D3564-5	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 200	Unit of Each	Qty on 44.0000	Remaining 1.0000	Qty	Date	Status
-------------------------------	-------------	----------------------	-----------	---------	------	--------------	-----------------	-------------------	---------------------	-----	------	--------



Wearshoe



Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	40	
51925	1	
54772 ✓	13	
55024	12	
55333	14	
Main Warehouse		
ST	2	
45824	1	
47433	1	

1 BR 10 3-10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 10

Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2594-3		Manufactured	No			200	Each	668.0000	16.0000			



O-Ring, 205 Skidtube



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	527	
51613	27	
55546 ✓	500	
Main Warehouse		
ST	141	
52562	141	

16, BK 10-3-10.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2594-1		Manufactured	No			200	Each	705.0000	16.0000			



Plug, 205 Skidtube



Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	FP	577	
	54008	1	
	54643	15	
	55002 ✓	561	
Main Warehouse	ST	128	
	42221	16	
	42807	92	
	43884	3	
	46435	2	
	51527	9	
	51757	6	

16, 10-3-10

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07.06.28 #

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56132

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
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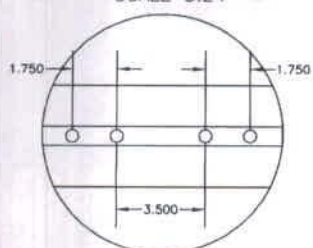
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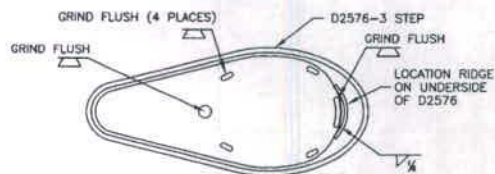
NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

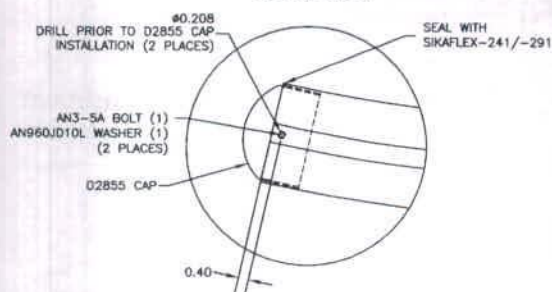


RELEASED
07 Dec 28

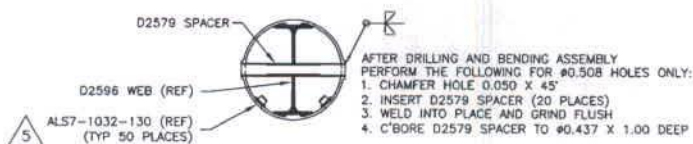
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SCALE 5:24



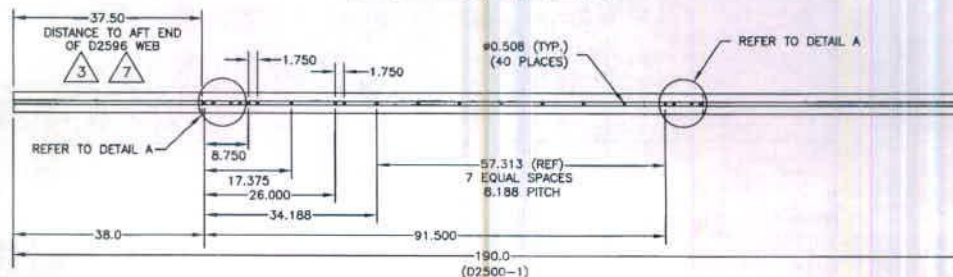
DETAIL C
SCALE 5:24



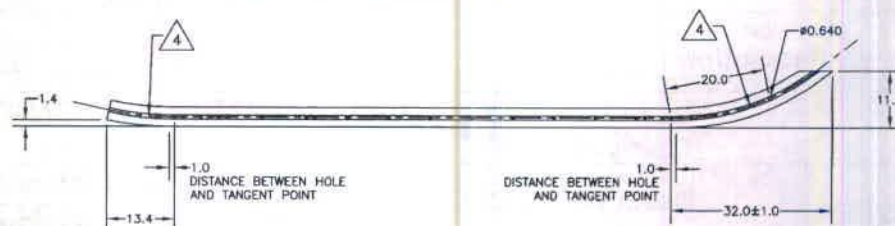
SECTION D-D
SCALE 5:24



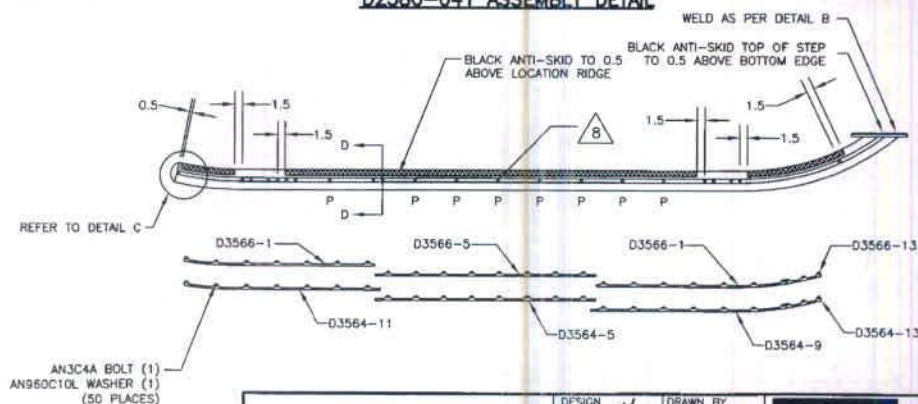
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

NO. 226

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 56134
Part number: D205 634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 10-02-23

Welder Barclay Elliott Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

